

Date: Wednesday, 11/02/2009 1:18:12 PM
 User: Julie Dawson

Process Sheet

split

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : COLLECTIVE LOCK
Job Number : 45748 -2	
Estimate Number : 11948	
P.O. Number :	Part Number : D3372041
This Issue : 11/02/2009 S.O. No. :	Drawing Number : D3372 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 41527	Material :
Written By :	Due Date : 28/02/2009 Qty: 6 Um: 8 Each
Checked & Approved By : JLD 09.02.11	
Comment : Est Rev:A Removed from 9 Digit 06-01-13 JLM	
Est Rev:B Added Key ID 06.03.21 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D27287	Dart Logo label
-----	--------	-----------------



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2728-7 Decal 22554

FF 09-04-06 (8)

2.0	D33721	Main Body
-----	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3372-1 Main Body B43258

FF 09-04-06 (8)

3.0	D33725	Cam Lock Shaft
-----	--------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3372-5 Cam Lock Shaft B22290

FF 09-04-06 (8)

4.0	D33727	Slider Body
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3372-7 Slider Body B22291x1

B43259x7

FF 09-04-06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/02/2009 1:18:12 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COLLECTIVE LOCK

Job Number: 45748

Part Number: D3372041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D33731

Cam Lock



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description

1 D3373-1 Cam Lock

Keys alike keys dislike

B 44105

B _____

CHECK WITH PRODUCTION IF KEYED ALIKE OR UNALIKE

FF 09-04-06

(8)

6.0

AN542A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN5-42A Bolt B 108084

FF 09-04-06

(8)

7.0

516WC

SS Flat Washer 5/16



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 5/16WC SS Flat Washer 110138

A/RN/ALocktite 262 109985

FF 09-04-06

(8)

8.0

D33841

Cyclic Sock



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3384-1 Cyclic Sock B 45752

FF 09-04-06

(8)

9.0

CBL460

Loop Sleeve



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CBL-460 Loop Sleeve 1109062

FF 09-04-06

(8)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COLLECTIVE LOCK

Job Number: 45748

Part Number: D3372041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

CBL1240

Cable



Comment: Qty.: 0.6999 f(s)/Unit Total : 5.5994 f(s)

Pick:

Qty Part Number Description Batch

8" CBL-1240 Cable 1107234

FF 09-04-06

(8)

11.0

AN960416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960-416 Washer 19356

FF 09-04-06

(8)

12.0

HX81

1/4"-20 SHCS 3/8" long



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 HX-81 1/4"-20 SHCS 3/8" long 1110383

FF 09-04-06

(8)

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Fabricate D3372-3 using AN5-42A bolt as per Dwg D3372

Identify as D3372-3

FF 09-04-06

(8)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/06

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Open Cam Lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.

2-Fabricate D3369-5 spacer using the flat cam as per Dwg D3369 Identify as D3369-5

FF 09/04/06

(8)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COLLECTIVE LOCK

Job Number: 45748

Part Number: D3372041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble D3372-053 as per Dwg D3372. Apply a drop of permanent locktite 262 to the threads

Qty Part Number Description Batch

A/R N/A

Locktite 262

109985

Identify as D3372-053

2-Assemble D3372-051 as per Dwg D3372. Identify as D3372-051 and attach keys. Ensure that assembly locks and unlocks smoothly.

3-Assemble lanyard to cyclic sock as per Dwg D3384

4-Assemble D3384-043 to D3372-051 using 1/4"-20 socket head cap screw and washers as per Dwg D3371.

FF 09-04-23

17.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Tack weld lock shaft as per Dwg D3372

Qty Part Number Description Batch

A/R N/A

SS Rod

1108775

CP 09-04-20

SP 09-04-07

18.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-04-21

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 09-04-23

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 486

Record Keys alike #

Record Keys dislike #


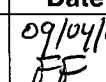
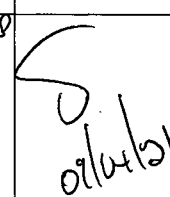

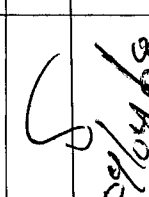
C400

9/4/21

SP

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3372-041 PAR #: N/A Fault Category: Prod/Asy mal ^{Small} NCR: (Yes) No DQA: 1 Date: 09/04/08
D350-740-011
 Resolution: Re-work Disposition: Re-work QA: N/C Closed: 1 Date: 09/04/08

NCR: <u>45748</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/4/7	#16	locks are installed incorrectly. They don't release the key and are sized ^{When lock welded they are sized} Fuel's grounded <u>PL Process During welding</u> <u>on inside</u>		Disassemble and scrub Locks. Replace <u>D3373-1</u> Re Assemble B <u>44105</u> x5 <u>5/16 wa x10 B 110138</u>	09/04/08 			

NOTE: Date & initial all entries

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User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COLLECTIVE LOCK

Job Number: 45748

Part Number: D3372041

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-04-21

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

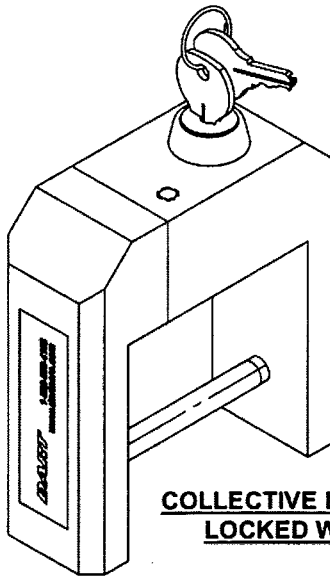
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

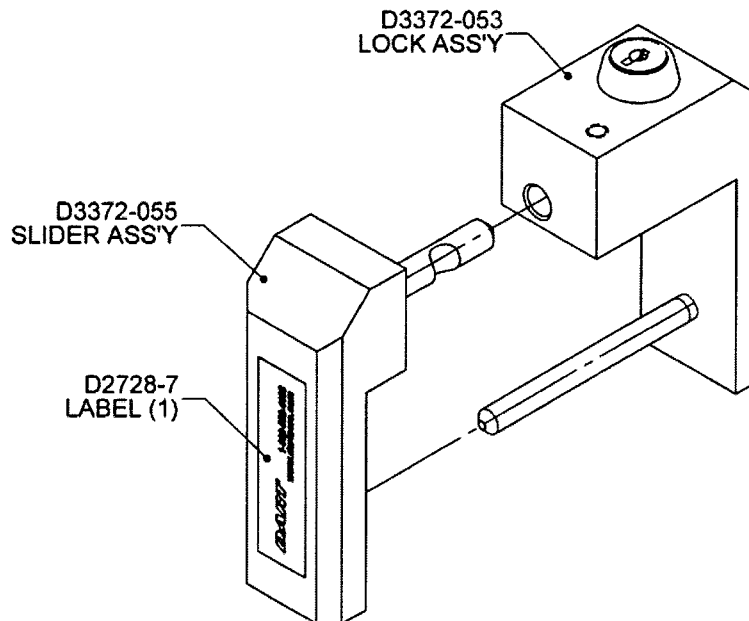
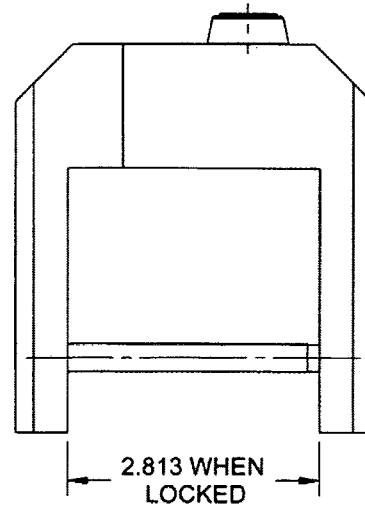
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2
A	05.01.10	NEW ISSUE	
B	05.02.23	REDESIGN FOR STANDARD 1/4 TURN LOCK, D3369-5 SUPERCEDES D3372-11 (OBSOLETE)	



**COLLECTIVE LOCK SHOWN
LOCKED WITH KEYS**



D3372-051 AS350 COLLECTIVE LOCK ASS'Y

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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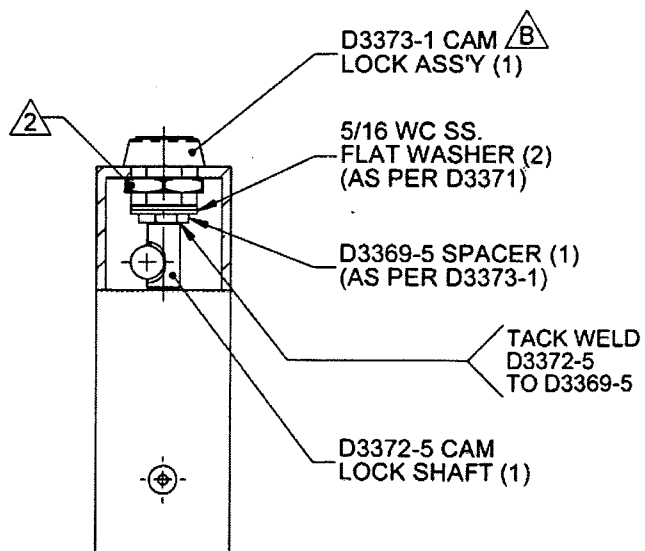
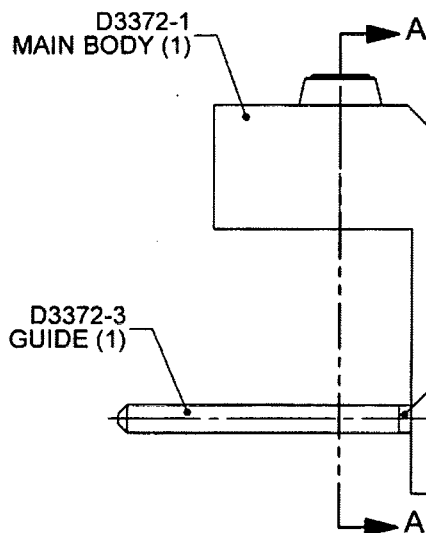
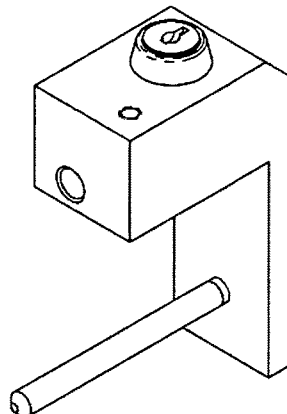
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

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SECTION A-A

D3372-053 LOCK ASS'Y

NOTES:

- 1) WELD PER DART QSI 004
- 2) APPLY THREADLOCKER LOCTITE 262 ON THREADS

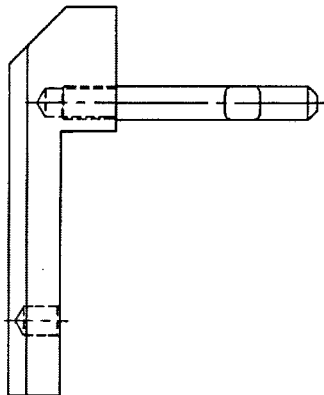
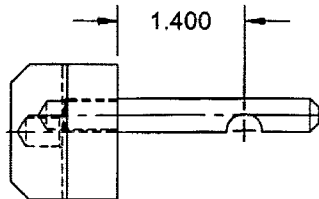
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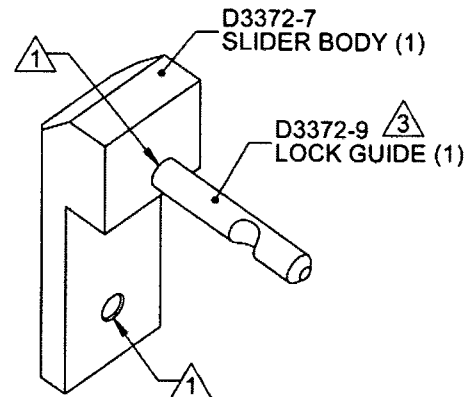
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

**RELEASED**

05/04/23

**D3372-055 SLIDER ASS'Y****NOTES:**

- 1) COVER INSIDE HOLES AND D3372-9 PRIOR PAINTING
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) APPLY THREADLOCKER LOCTITE 262 ON D3372-9 THREADS PRIOR ASSEMBLY
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

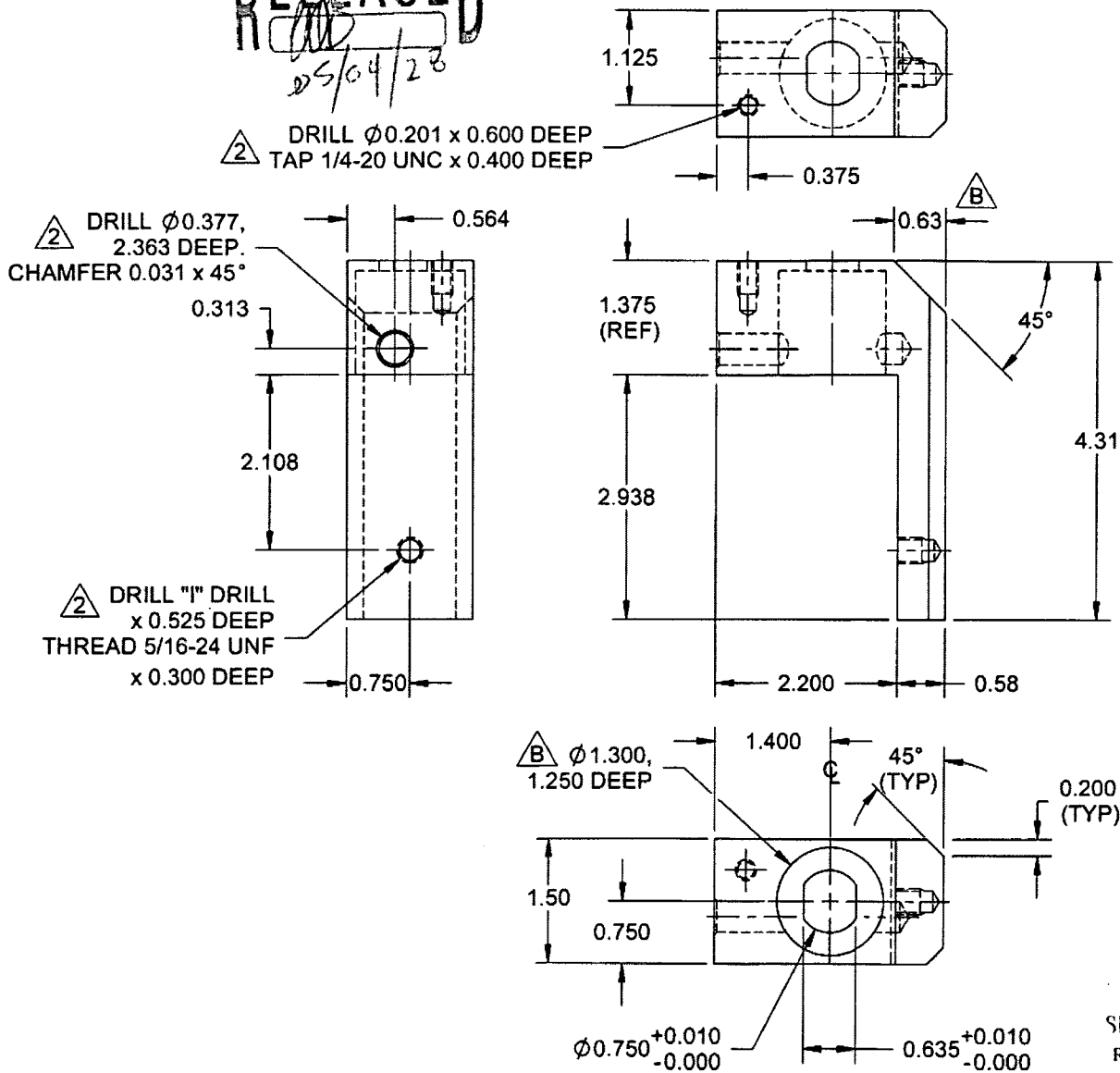
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

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05/04/23**D3372-1 MAIN BODY****NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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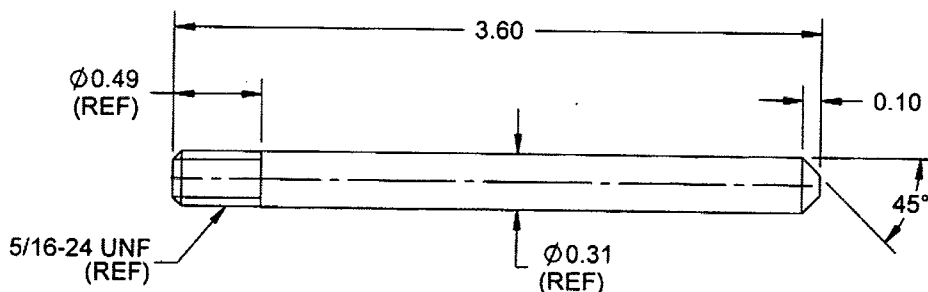
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:1

SPECIFICATION CONTROL DRAWING

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[Signature]
05/04/23



D3372-3 GUIDE

NOTES:

- 1) MATERIAL: AN5-42A BOLT MODIFIED AS SHOWN.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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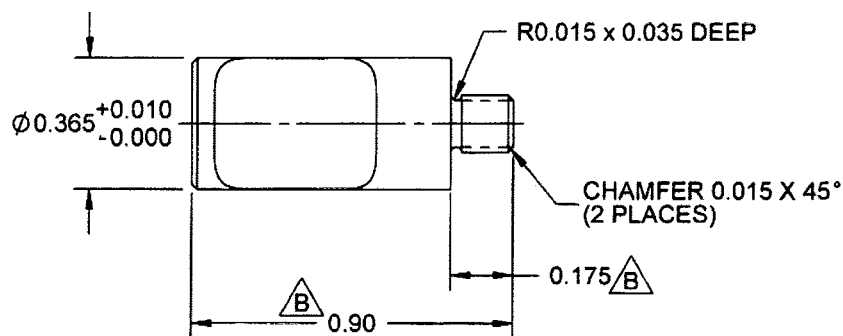
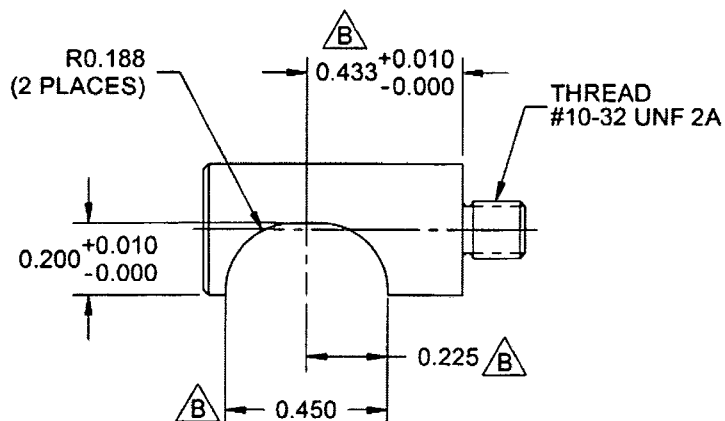
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

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05/04/28



D3372-5 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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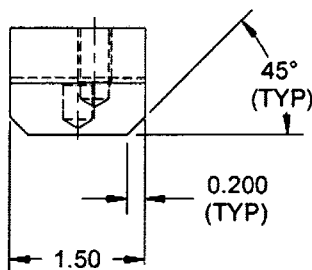
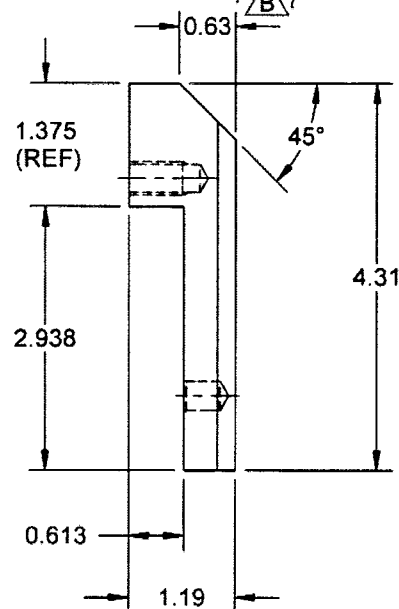
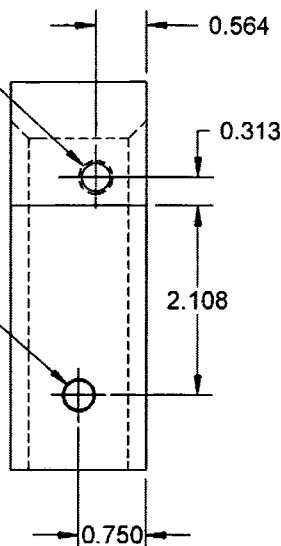
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

DRILL $\phi 0.332$
("Q" DRILL) x 0.881 DEEP,
THREAD 3/8-24 UNF x 0.600 DEEP

DRILL $\phi 0.323$
("P" DRILL) x 0.500 DEEP
CHAMFER 0.030 x 30°



D3372-7 SLIDER BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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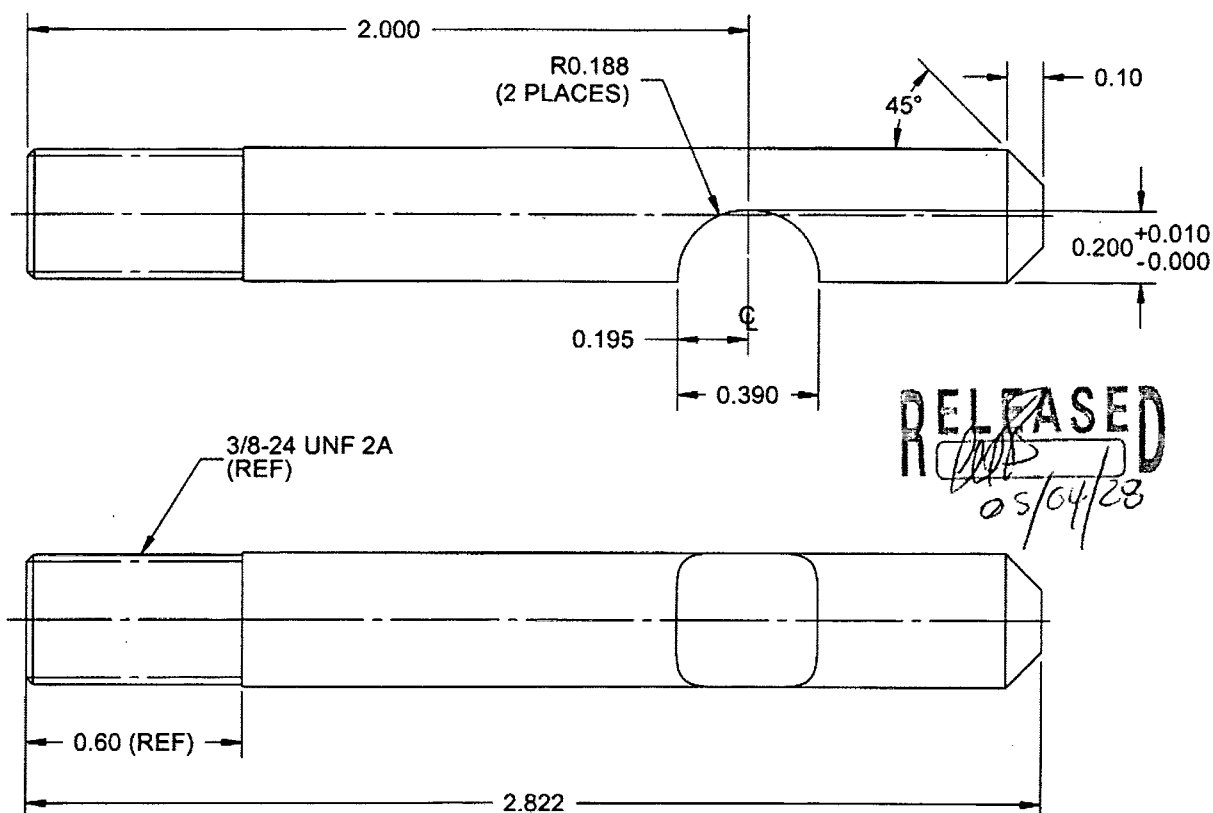
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

SPECIFICATION CONTROL DRAWING



D3372-9 LOCK GUIDE

NOTES:

- 1) MATERIAL: AN6-36A BOLT, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

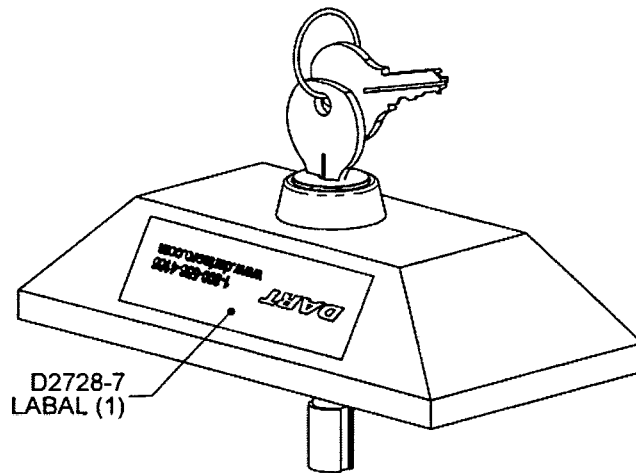
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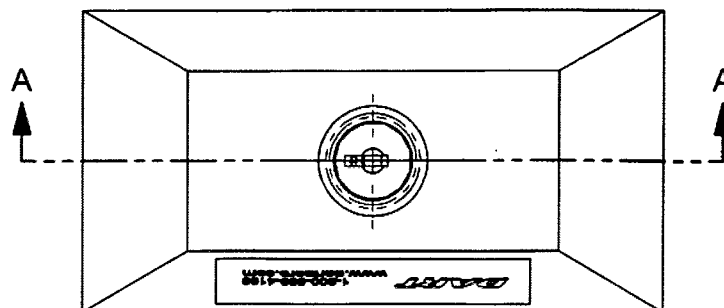
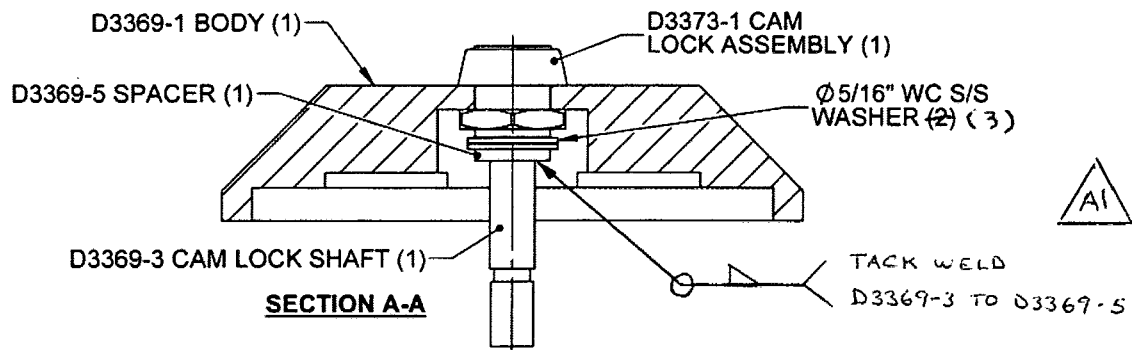
DART

DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RE	APPROVED MS	DRAWING NO. D3369	REV. A SHEET 1 OF 4
DATE 04.12.16		TITLE BATTERY LOCK	SCALE 1:1.5
A	04.12.16	NEW ISSUE	



BATTERY LOCK SHOWN LOCKED WITH KEY

RELEASED
05/02/11



D3369-041 BATTERY LOCK ASSEMBLY

NOTES:

- 1) WELD PER DART QSI 004

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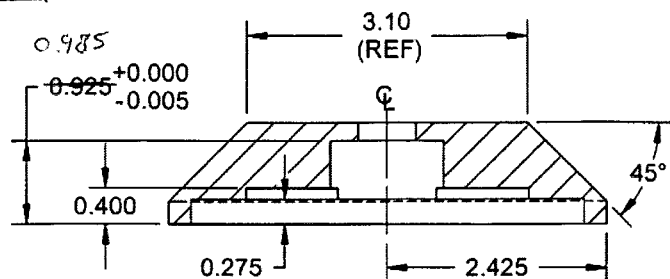
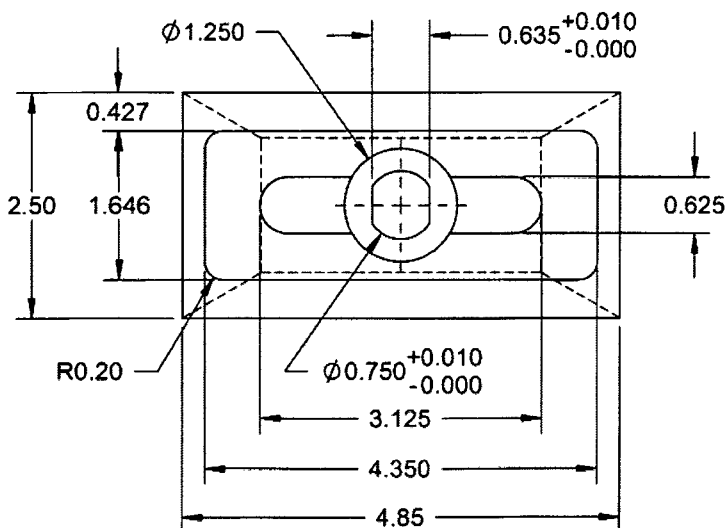
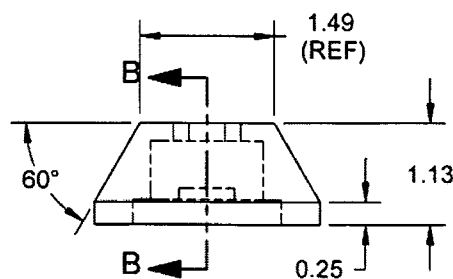
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A1 MDR 05.02.11 ADD TACK WELD 0.865 WAS 0.925

DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3369	REV. A SHEET 2 OF 4
DATE 04.12.16		TITLE BATTERY LOCK	SCALE 1:2

A1**SECTION B-B****RELEASED**
[Signature]

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D3369-1 BODY**NOTES:**

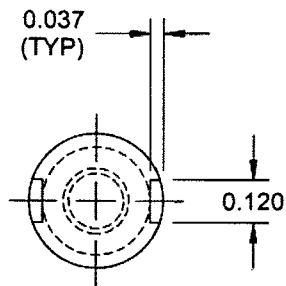
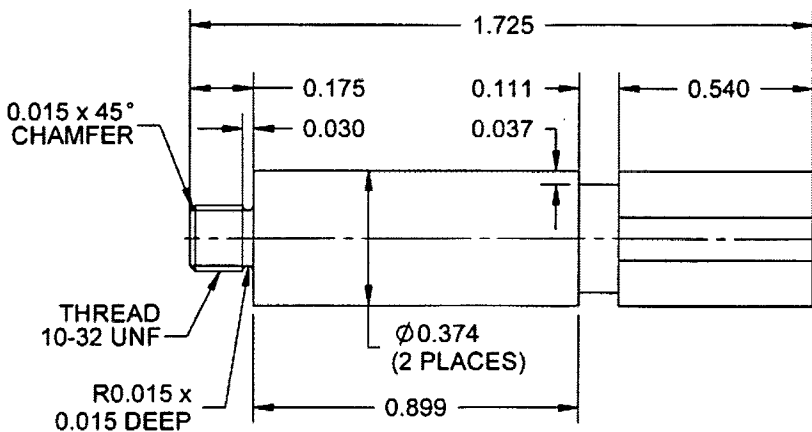
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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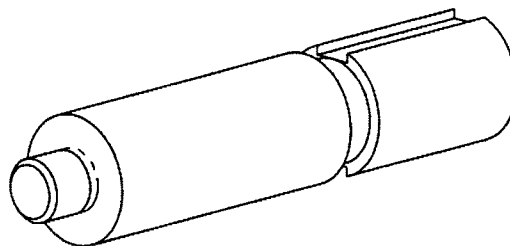
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DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3369	REV. A SHEET 3 OF 4
DATE 04.12.16		TITLE BATTERY LOCK	SCALE 2:1



RELEASED
[Signature]
05/02/11



D3369-3 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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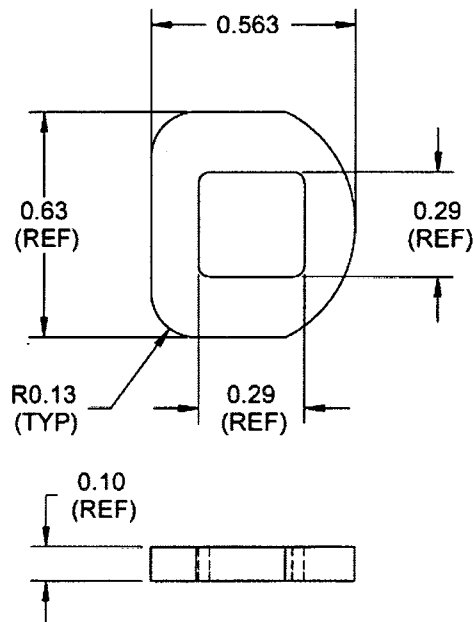
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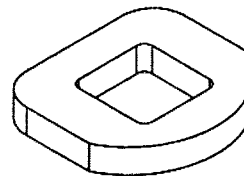
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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3369	REV. A SHEET 4 OF 4
DATE 04.12.16		TITLE BATTERY LOCK	SCALE 2:1

SPECIFICATION CONTROL DRAWING

**RELEASED**
[Signature]

05/02/11



-5
D3369 SPACER

**NOTES:**

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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